

Work Order ID 64547

December 21, 2010 2:30:32 PM

Page 2

Item ID: D212-664-201

Accept

Setup Start

Revision ID:

Stop

Item Name: Crosstube Aft

Start Date: 12/08/10 Start Qty: 1.00

Required Date: 12/09/10 Req'd Qty: 1.00

Cust Item ID:

Customer: CU-DAR001

Reference: RMA RA110139

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00



Crosstubes

Crosstubes

Memo

-BUFF CORROSION
-ACID ETCH AND ALODINE
-RE-PRIME UNDER SUPPORTS, REINSTALL SUPPORTS

allow primer to dry for 4hrs min } 11-01-10
then assemble

0.00

111

Outsource

LPI per DSE

PO 13250

C 211/01/10

(41)

Per 1/1/10

7 Dec 5 - inspect supports → S. L. L. L.

120

QC21 - Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

W/O: 64547		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11-01-10	110	prime inside of original supports leave exterior S/S	ET	11-01-10	x 2	W 11-01-11	S initial	
11-01-10	110	install new clamps MS21920-28 B <u>m 14749</u> install new rubber strips Q3595-063-530 B <u>59581</u>	ET	11-01-10		W 11-01-11	S initial	

Part No: D212-664-201 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 64547

December 21, 2010 2:30:33 PM

Page 3

Item ID: D212-664-201

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Stop

Item Name: Crosstube Aft

Start Date: 12/08/10 Start Qty: 1.00

Cust Item ID:

Required Date: 12/09/10 Req'd Qty: 1.00

Customer: CU-DAR001


Reference: RMA RA110139

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
1150		0.00							
									
Packaging	Memo	0.00							
Packaging	PACKAGE, RETURN TO CUSTOMER								

Ac 21 -

Co 11/21/11 ①
11/01/12 J
11/26/11

Picklist Print

Page 1

December 21, 2010 2:30:31 PM

Work Order ID: 64547

Parent Item: D212-664-201

Parent Item Name: Crosstube Aft



Start Date: 12/08/10

Required Date: 12/09/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:E 04.02.16 Reformat K/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 07-04-30 As per Rev C JLM
 IPP Rev:H 08-05-22 up date Qty of rubber cushion DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D212-664-201		Manufactured	No				Each	10.0000		1			
Crosstube Aft													

Location	Loc Qty	Loc Code
FG	1	
38844	1	
39659	1	
60449	1	
FG103	7	
60523	1	
60524	1	
60557	1	
61738	1	
61739	1	
63538	1	
63539	1	

60450

customer
Return

h

L Lacelle

From: Bill Beckett [bbeckett@dartaero.com]
Sent: December 20, 2010 12:55 PM
To: 'Peggy McDonald'; swillems@dartaero.com; 'L Lacelle'
Cc: 'Marc Bellavance'; Jason Murdoch; 'Stow, Dan'; Susanne Sheldon; 'Mike Petsche'; 'David Shepherd'
Subject: RE: Crosstube corrosion from Expedition

Peggy – ok, this is fine.

Sian – no-charge on a CSR. Please indicate ship date (talk to LL).

Linda – pls prepare work order **NB – no priming!** Ensure interior is protected during etch and alodine.

Bill

From: Peggy McDonald [mailto:peggy@darths.com]
Sent: December 20, 2010 12:48 PM
To: Bill Beckett
Cc: Marc Bellavance
Subject: Crosstube corrosion from Expedition
Importance: High

Hi Bill,

I spoke with Expedition this morning about the crosstube corrosion issue.

To resolve the issue, I took your recommendation and offered the crosstube rework at no charge.
 (removal of the surface corrosion, acid etch and alodine)

PLEASE NOTE : the customer will do their own priming right before paint.

These can be returned to them early in the new year.
 I recommend a MISC no charge PO to be sent to DAS.
 Freight will be on the DHS account.

Please advise how you would like DHS to proceed.

Peggy

*- Buff corrosion
 - acid etch
 - alodine
 - reassemble; prime under supports*

*64541
 547
 60522
 60450*

PLEASE NOTE OUR NEW CORPORATE OFFICE ADDRESS: 4650 North Avenue, Oceanside, California 92056

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12/20/10

Work Order ID 64547

December 8, 2010 8:52:43 AM



Page 1

Item ID: D212-664-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 12/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/09/10 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA110139

Approvals:

Process Plan: U

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-241	Rev D								

100

0.00



QC

Memo

0.00

Quality Control

INSPECT RA110139

Work Order ID 64547

December 8, 2010 8:52:43 AM

Page 2



Item ID: D212-664-201

Accept



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Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 12/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/09/10 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA110139

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



Crosstubes

Memo

0.00

Crosstubes

Verified by: *ml/ml* 10/11/08*ml* 10 11 08 (1)

120

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

verified by

[illegible]



LIQUID PENETRANT TEST REPORT

P- 15201

CLIENT	DACT Aerospace	DATE	Jan. 10, 2011	PAGE	1	OF	1	
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188-11-2008	TIME	AM	<input checked="" type="checkbox"/>	PM	<input type="checkbox"/>
ADDRESS	1270 ABERDEEN ST HAWKES BURY, CN.	PO/VO No.		WORK LOCATION	Hawkesbury Plant			
PROJECT	F. P. I.	ACCEPTANCE STD.	ASTM 1417	REV./DATE	2005			
ITEM(S) EXAMINED	6 CROSS TUBES 2 ENGINE MOUNTS							

JOB DESCRIPTION	PROCEDURE NO. LT-001	REV./DATE	2008	TECHNIQUE NO. LT-002	REV./DATE	2008
PART NO.	MATERIAL ALUMINUM THICKNESS VARIOUS					
SCOPE	WET FLUORESCENT LIQUID PENETRANT INSPECTION COPIED OUT 100% EXTERNAL					

TEST DETAILS	
METHOD	<input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE
FAMILY BRAND	MAINA FLUX
PENETRANT	2LG7 MINIMUM DWELL TIME 45 10 MIN.
PENETRANT REMOVER	H2O MINIMUM DRY TIME >10 MIN.
DEVELOPER	SAD52 MINIMUM DWELL TIME 10 MIN.
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY
WATER WASH <input checked="" type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED	
BLACK LIGHT S/N 18454 <input type="checkbox"/> OUTPUT > 1000 μ W/cm ² <input type="checkbox"/> AMBIENT < 2 fc	
LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE	
OTHER LAB. NO.	
LIGHT METER S/N 1048866 CAL DUE DATE 06-19-2011	

TEST SURFACE	
SURFACE CONDITION	<input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/ 50°F <input type="checkbox"/> 10°C/ 50°F TO 52°C/ 125°F <input type="checkbox"/> > 52°C/ 125°F

RESULTS-	<input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL
----------	---

1 - CROSS TUBE - W.C. 63783	✓
1 - CROSS TUBE - W.C. 63784	✓
1 - CROSS TUBE - W.C. 63573	✓
1 - CROSS TUBE - W.C. 63524	✓
1 - CROSS TUBE - W.C. 64541	✓
1 - CROSS TUBE - W.C. 64547	✓
1 - REPLACEMENT ENGINE MOUNT	✓
- W.C. 63456 - D3607-1	✓
1 - H2O D3607-3	✓

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	PRINT: Dan Titley
TECHNICIAN (SIGNATURE):	SIGNATURE: [Signature]
NAME (PRINT):	1 ST TECHNICIAN: [Signature]
	2 ND TECHNICIAN:
CGSB LEVEL	SNT LEVEL
CGSB REG. NO.	CGSB REG. NO.
DTR # EG3740	
REPORT REVIEWED BY:	
NAME	INITIALS

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY

Item	Qty -241	Qty -241B	Part Number	Description
1	X		D212-664-241	CROSSTUBE ASSEMBLY (205/212 HIGH AFT)
2		X	D212-664-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6006-129	CROSSTUBE
4	2	2	D2940-1	SUPPORT
5	4	4	D3595-063-530	RUBBER CUSHION
6	4	4	MS21920-28	CLAMP (OR MS21920-30)
7	A/R	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6006-129
FINISHED LENGTH = 124.362±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D212-664-XXX" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: D212-664-241 = 44.2 lbs (PER IIN-D212-664)
D212-664-241B = 44.2 lbs (PER IIN-D212-664)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2940-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2940-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-063-530 RUBBER CUSHIONS TO SECURE THE D2940-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

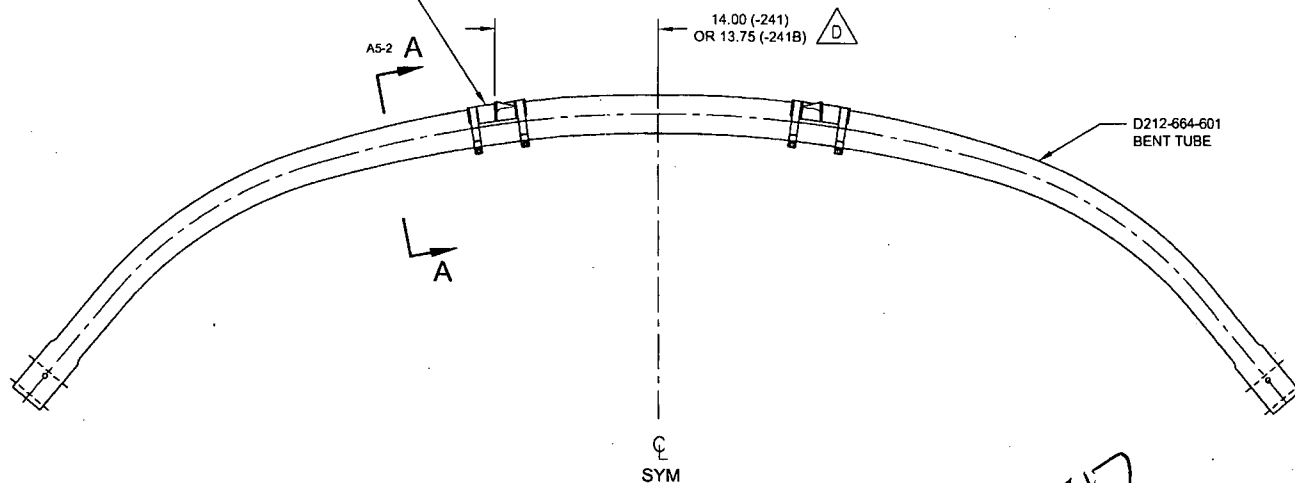
D	REFORMAT/REVISE GENERAL NOTES/PART LIST; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; ADD -241B (ZN D4-2, B4-2); REMOVED REF & ADD TOLERANCES (ZN D8-3 & C4-3, C8-3 & A8-3); RELOCATED FLAG #6 PER PAR 08-046 (ZN A8-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	09.09.30
C	REMOVE -1009 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	00.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-241	SHEET 1 OF 4
APPROVED	PH	TITLE	SCALE
DATE	09.09.30	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS

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RELEASED
2009-10-29

64547

12 13 15
 D2940-1 SUPPORT
 MS21920-28 CLAMP, 2X
 D3595-063-530 RUBBER CUSHION, 2X
 2 PL



**D212-664-241/-241B
 ASSEMBLY DETAIL** D

64547

12
 APPLY MAGNOBOND
 BETWEEN D2940-1 AND
 CROSSTUBE

12

13 15
 MS21920-28
 CLAMP, REF

13 15

D3595-063-530 RUBBER CUSHION
 UNDER CLAMP, REF

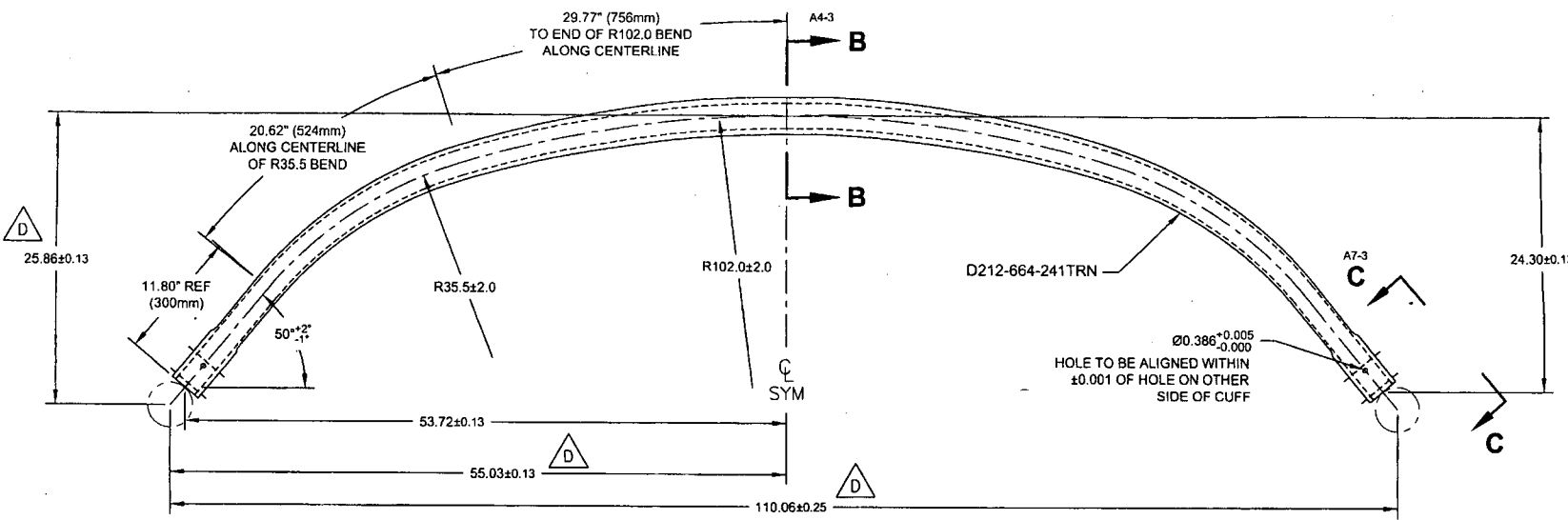
D2940-1 SUPPORT, REF

SECTION A-A D6-2
 SCALE 4X

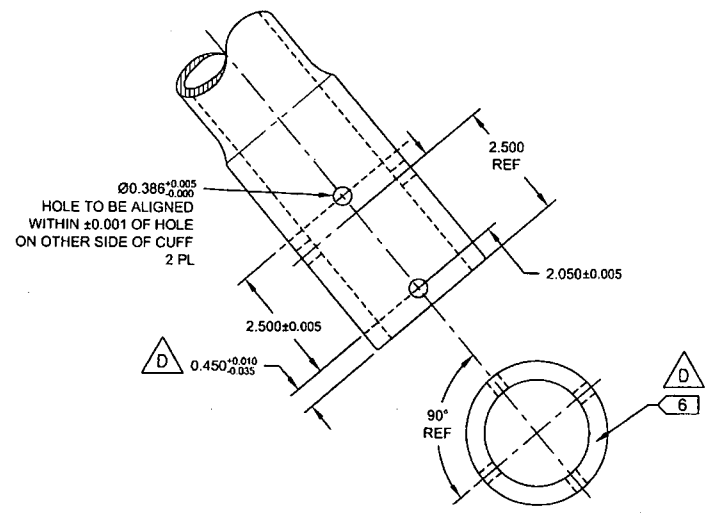
RELEASED
 2009-10-28

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. D
MFG. APPR.	PH	D212-664-241	SHEET 2 OF 4
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	CROSSTUBE ASS'Y (205/212 HI AFT)	NTS
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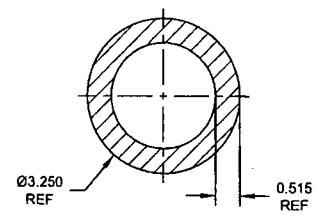
8 7 6 5 4 3 2 1



D212-664-601 10 D
BENDING AND DRILLING DETAIL



VIEW C-C: CUFF DETAIL D2-3
 SCALE 3X



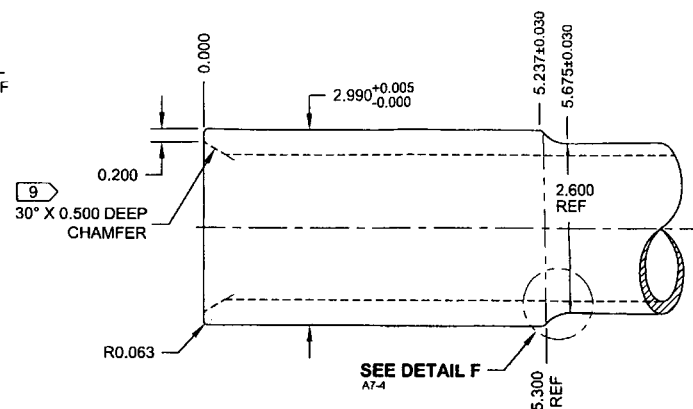
SECTION B-B D4-3
 SCALE 4X

64547

RELEASED
 2009-10-29

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. D
MFG. APPR.	10	D212-664-241	SHEET 3 OF 4
APPROVED	10	TITLE	SCALE
DE APPR.	10	CROSSTUBE ASSY (205/212 IN. AFT)	NTS
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8 7 6 5 4 3 2 1



 **D212-664-241TRN**
TURNING DETAIL

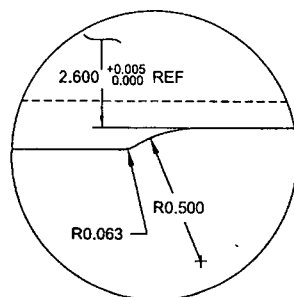


Figure 1 shows a circular cross-section of a part with three vertical features. Each feature has a top dimension of $+0.005$ and a bottom dimension of 0.000 . The top dimensions are 3.179 , 3.250 , and 3.276 . The bottom dimensions are 42.114 REF, 45.042 REF, and 46.114 REF. A dashed horizontal line is drawn across the top of the features. A solid horizontal line is drawn across the bottom of the features. A vertical line is drawn through the center of the part. A dimension line with arrows at both ends is drawn across the bottom of the part, labeled $R100.0$ REF. A callout box with the number 9 points to the bottom of the part, labeled RUN OFF PART.

DETAIL E:
TAPER RUN-OFF C5-4
NOT TO SCALE

64547

RELEASED
2009-10-29
MJP

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	Q	DRAWING NO.	REV. D
MFG. APPR.	IS	D212-664-241	SHEET 4 OF 4
APPROVED	NO	TITLE	SCALE
CE APPR.	TH	CROSSTUBE ASSY (205/212 HI AFT)	NT
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Kim Johnston

From: L Lacelle <llacelle@dartaero.com>
Sent: Wednesday, January 12, 2011 9:04 AM
To: 'Kim Johnston'
Subject: FW: Crosstube corrosion from Expedition

That's for the 2 w/o's you rec'd yesterday

From: the.sheldons@sympatico.ca [mailto:the.sheldons@sympatico.ca] **On Behalf Of** Susanne Sheldon
Sent: January 12, 2011 8:22 AM
To: 'L Lacelle'
Cc: 'Stow, Dan'; swillems@dartaero.com; 'Marc Bellavance'; 'Jason Murdoch'; 'David Shepherd'; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition

I suggest keeping the same batch number and reference the re-work work order on the old work order for traceability
Susanne

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: January 11, 2011 8:47 AM
To: 'Susanne Sheldon'
Cc: 'Stow, Dan'; swillems@dartaero.com; 'Marc Bellavance'; 'Jason Murdoch'; 'David Shepherd'; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition
Importance: High

So these have been NDT'd and supports re-installed, all of this was done on w/o's, so my question is, do we send them out under the new B/N ? IF we do, this will screw up our costs of D212-664-101 & -201, as there was no cost entered in the RMA. Any suggestions?

LL

From: David Shepherd [mailto:dshepherd@dartaero.com]
Sent: January 5, 2011 5:21 PM
To: 'Jason Murdoch'; 'L Lacelle'; 'Marc Bellavance'
Cc: 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; swillems@dartaero.com; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition

Jason,

I would recommend that we NDT them.

David

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Wednesday, January 05, 2011 1:59 PM
To: 'L Lacelle'; 'Marc Bellavance'
Cc: 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition

Will these tubes be NDT'd before they ship back to the customer? I do not want DART being held responsible for any issues that might occur down the road.....ya mean?

Jason Murdoch
Quality Coordinator
jmurdoch@dartaero.com
DART Aerospace Ltd.
613-632-5200

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 05, 2011 1:55 PM
To: 'Marc Bellavance'
Cc: 'Jason Murdoch'; 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition

With everyone gone for the last couple of weeks no one really touched them. They will get ground today, and alodined and we should be able to ship out by Friday.

LL

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: January 5, 2011 1:49 PM
To: 'L Lacelle'
Cc: 'Jason Murdoch'; 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition
Importance: High

Linda,

Where are we with this? Customer wants to know.

Marc Bellavance
Technical/Shop Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 243

Cel: 613-676-0992

Fax: 613-632-9311

E-mail: mbellavance@dartaero.com

Web: www.dartaero.com

Product Documentation: Verify Revision Status/Download [HERE!](#)



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From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: December 20, 2010 12:55 PM
To: 'Peggy McDonald'; swillems@dartaero.com; 'L Lacelle'
Cc: 'Marc Bellavance'; Jason Murdoch; 'Stow, Dan'; Susanne Sheldon; 'Mike Petsche'; 'David Shepherd'
Subject: RE: Crosstube corrosion from Expedition

Peggy – ok, this is fine.

Sian – no-charge on a CSR. Please indicate ship date (talk to LL).

Linda – pls prepare work order **NB – no priming!** Ensure interior is protected during etch and alodine.

Bill

From: Peggy McDonald [mailto:peggy@darths.com]

Sent: December 20, 2010 12:48 PM

To: Bill Beckett

Cc: Marc Bellavance

Subject: Crosstube corrosion from Expedition

Importance: High

Hi Bill,

I spoke with Expedition this morning about the crosstube corrosion issue.

To resolve the issue, I took your recommendation and offered the crosstube rework at no charge.
(removal of the surface corrosion, acid etch and alodine)

PLEASE NOTE : the customer will do their own priming right before paint.

These can be returned to them early in the new year.

I recommend a MISC no charge PO to be sent to DAS.

Freight will be on the DHS account.

Please advise how you would like DHS to proceed.

Peggy

PLEASE NOTE OUR NEW CORPORATE OFFICE ADDRESS: 4650 North Avenue, Oceanside, California 92056

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61001 Hwy 11 west, P.O. Box 160
Cochrane, ON P0L 1C0
Phone: 1-705-272-5755 Fax: 1-705-272-5752
guylain@expeditionhelicopters.com

Packing Slip	
Packing Slip No.	1285
Date	Dec 3, 2010
Created By	Suzanne
Type	RMA#RA110139 "SQ10210"
Currency	USD
Page 1 / 1	

RMA#RA110139 "SQ10210" #1285

To DART HELICOPTER SERVICES 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 CANADA Tel: 613-632-3336, Fax: 613-632-4443 OR 800-556-4166	Order from 190 HWY 11 WEST PO.BOX 160 COCHRANE, ONTARIO P0L1C0 Tel: (705)-272-5755, Fax: (705)-272-5752
Ship to SAME 190 HWY 11 WEST, PO BOX 160 COCHRANE, ONTARIO P0L 1C0 Tel: (705) 272-5755, Fax: (705) 272-5752	Bill to SAME 190 HWY 11 WEST, PO BOX 160 COCHRANE, ONTARIO P0L 1C0 Tel: (705) 272-5755, Fax: (705) 272-5752

**** Work to be accomplished at this time ****

Please, perform RMA#RA110139 "SQ10210"

Parts description

Part Number	Description	Tracking #	Ser/Batch #	TTSN	TTSO	Reg	Est. Cost
D212-664-101	CROSSTUBE FWD	11898	B60522			C-FMQN	0.00
Defect	TO BE SENT TO DART HELICOPTERS FOR WARRANTY EVALUATION AS PER JEAN KERR RETURN AUTHORIZATION #RA110139 "SQ10210"						

Part Number	Description	Tracking #	Ser/Batch #	TTSN	TTSO	Reg	Est. Cost
D212-664-201	CROSSTUBE AFT	11899	B60450			C-FMQN	0.00
Defect	TO BE SENT TO DART HELICOPTERS FOR WARRANTY EVALUATION AS PER JEAN KERR RETURN AUTHORIZATION #RA110139 "SQ10210"						


Signature


Date



4650 North Avenue, Oceanside, CA 92056
Tel: 1-760-295-6094 Fax: 1-760-295-9117
E-mail: sales@darths.com

RETURN AUTHORIZATION

Date: Dec. 03/10
To: Expedition Helicopters Inc.
Attention: Guylain Tremblay
E-Mail: guylain@expeditionhelicopters.com
From: Jean

Dear Guylain

Please find below the instructions to return the **D212-664-101/201** ordered on your Purchase Order **2427**.

1. Your Return Authorization Number is **RA110139**. Please make reference to this number on all paperwork. Items must still be in original packaging. Please label the crosstubes with "**SQ10210**".
2. The Original Release Certificate, STC's, Installation Instructions, Maintenance Manual Supplement, Flight Manual Supplement, and packing slips must accompany the shipment.
3. Please mark the shipping labels to:
Dart Aerospace,
1270 Aberdeen Street,
Hawkesbury, Ontario.
Canada K6A 1K7
Tel.: 1-613-632-5200
4. Brad from Journey Freight (tel 514-447-0242, ext. 3242) will contact you for the pick up of the crosstubes. This Return Authorization expires in 30 days. The Quality Control at Dart Aerospace will evaluate the crosstubes and will notify you once completed.

If you require additional information, please feel free to contact us. **DART HELICOPTER SERVICES, LLC** is always pleased to assist you with your helicopter needs.

Best Regards,

Jean Kerr
Sales Support
DART HELICOPTER SERVICES, LLC



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 5200
Fax: 613 632 5246

Packing Slip

Packing Slip Number : INV102995

Customer Purchase Order ID : 7601/2427

Sales Order ID : SO103029

Ship Date : 8/24/2010 12:58:00 PM

Page Number : 2

Bill To : CU-DAR001

DART HELICOPTERS SERVICES LLC.
1736 ORD WAY
OCEANSIDE, CA 92056
US

Ship To :

EXPEDITION HELICOPTERS, INC.
190 HWY 11 WEST
COCHRANE, ON P0L 1C0
CA

Contact Name: Suzanne Arsenault

Contact Phone: 705 272 5755

Contact Phone Ext.:

Buyer:

Order Date: 8/24/2010 12:46:25 PM
Manitoulin Ground Coll

FOB: Origin
Territory: CA Central

Ship From: MAIN WAREHOUSE

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7 CANADA

Bill of Lading :

Pallets 0
Cartons 0
Weight 0

Ship From Phone: 613 632 5200

<u>Line /</u>	<u>Item ID /</u>	<u>Item Name</u>	<u>Harmonize Code:</u>	<u>Req. Date</u>	<u>Req. Qty</u>	<u>Ship Qty</u>	<u>Backordered Qty</u>
<u>Cust PO Line Nbr</u>	<u>Cust Item ID</u>						
4	D205-634-011		8803.20	8/24/2010	1.0000	1.0000	0.0000
4	Skidtube				Each	Each	

Special
Instructions:

Lot Number
60690

Lot Trans Qty
1.0000

As per FAA STC requirement, this is written evidence that Dart Aerospace Ltd. gives the above Ship-to permission to use the STC(s) for the above shipped part(s) to alter the product listed in the STC(s).

Special
Instructions for
Sales Order:



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 5200
Fax: 613 632 5246

Packing Slip

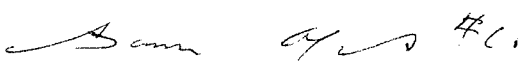
Packing Slip Number : INV102995
Customer Purchase Order ID : 7601/2427
Sales Order ID : SO103029
Ship Date : 8/24/2010 12:58:00 PM
Page Number : 1


Bill To : CU-DAR001 DART HELICOPTERS SERVICES LLC. 1736 ORD WAY OCEANSIDE, CA 92056 US		Ship To : EXPEDITION HELICOPTERS, INC. 190 HWY 11 WEST COCHRANE, ON P0L 1C0 CA	
Buyer:		Contact Name: Suzanne Arsenault Contact Phone: 705 272 5755 Contact Phone Ext.:	
Order Date: 8/24/2010 12:46:25 PM Bill of Lading :	FOB: Origin Territory: CA Central	Ship From: MAIN WAREHOUSE DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CANADA	
	Pallets 0 Cartons 0 Weight 0	Ship From Phone: 613 632 5200	

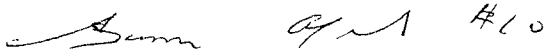
<u>Line /</u>	<u>Item ID /</u>	<u>Item Name</u>	<u>Harmonize Code:</u>	<u>Req. Date</u>	<u>Req. Qty</u>	<u>Ship Qty</u>	<u>Backordered Qty</u>
<u>Cust PO Line Nbr</u>	<u>Cust Item ID</u>						
1	D212-664-101		8803.20	8/24/2010	1.0000	1.0000	0.0000
1	Crosstube Fwd				Each	Each	
Special Instructions:		<u>Lot Number</u>				<u>Lot Trans Qty</u>	
		60522				1.0000	
2	D212-664-201		8803.20	8/24/2010	1.0000	1.0000	0.0000
2	Crosstube Aft				Each	Each	
Special Instructions:		<u>Lot Number</u>				<u>Lot Trans Qty</u>	
		60450				1.0000	
3	D205-634-011		8803.20	8/24/2010	1.0000	1.0000	0.0000
3	Skidtube				Each	Each	
Special Instructions:		<u>Lot Number</u>				<u>Lot Trans Qty</u>	
		59280				1.0000	


As per FAA STC requirement, this is written evidence that Dart Aerospace Ltd. gives the above Ship-to permission to use the STC(s) for the above shipped part(s) to alter the product listed in the STC(s).

Special
Instructions for
Sales Order:

1. Approving Civil Aviation Authority/Country: Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE				3. Form Tracking No: SO103029-2	
4. Organizations Name and Address:		DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON, K6A 1K7 Canada				5. Work Order/Contract/Invoice 7601/2427	
6. Item:	7. Description:	8. Part No:	9. Quantity:	10. Serial/Batch No:	11. Status/Work:		
1	Crosstube Aft	D212-664-201	1	B60450	New		
12. Remarks: TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06							
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 has been performed in compliance with the Canadian Aviation Regulations.				
13b. Signature: 		13c. Approved Organization Number: 9-89		14b. Signature: N/A		14c. Approved Organization Number: N/A	
13d. Name: Suzanne Bedford		13e. Date (dd/mm/yyyy): 24/Aug/2010		14d. Name: N/A		14e. Date (dd/mm/yyyy): N/A	
(Previously form 24-0078)							
<div style="display: flex; justify-content: space-between;"> <div> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p> </div> <div style="text-align: center;"> <p>Installer Responsibilities</p> </div> <div> <p>Important: See notes</p> </div> </div>							

1. Approving Civil Aviation Authority/Country: Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No: SO103029-1	
4. Organizations Name and Address:		DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON, K6A 1K7 Canada			Tel: 1 613 632 5200 Fax: 1 613 632 5246 www.dartaero.com	
		5. Work Order/Contract/Invoice 7601/2427				
6. Item:	7. Description:	8. Part No:	9. Quantity:	10. Serial/Batch No:	11. Status/Work:	
1	Crosstube Fwd	D212-664-101	1	B60522	New	
12. Remarks: TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06						
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 has been performed in compliance with the Canadian Aviation Regulations.			
<input checked="" type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.						
13b. Signature:		13c. Approved Organization Number:	14b. Signature:		14c. Approved Organization Number:	
		9-89	N/A		N/A	
13d. Name:		13e. Date (dd/mm/yyyy):	14d. Name:		14e. Date (dd/mm/yyyy):	
Suzanne Bedford		24/Aug/2010	N/A		N/A	
(Previously form 24-0078)						
<div style="text-align: right;">Important: See notes</div> <div style="text-align: center;">Installer Responsibilities</div> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

1. Approving Civil Aviation Authority/Country: Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No: SO103029-4	
4. Organizations Name and Address: DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON, K6A 1K7 Canada				Tel: 1 613 632 5200 Fax: 1 613 632 5246 www.dartaero.com		
5. Work Order/Contract/Invoice 7601/2427						
6. Item:	7. Description:	8. Part No:	9. Quantity:	10. Serial/Batch No:	11. Status/Work:	
1	Skidtube	D205-634-011	1	B60690	New	
12. Remarks: TC STC SH96-88 Issue 3, FAA STC SR00563NY 08/08/11, EASA STC EASA.IM.R.S.01303 07/06/27, JCAB JAPAN STC-55-1-TYO 99/11/24						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature: 		13c. Approved Organization Number: 9-89	14b. Signature: N/A		14c. Approved Organization Number: N/A	
13d. Name: Suzanne Bedford		13e. Date (dd/mm/yyyy): 24/Aug/2010	14d. Name: N/A		14e. Date (dd/mm/yyyy): N/A	
(Previously form 24-0078) Important: See notes						
<p>This certificate does not constitute authority to install.</p> <p style="text-align: center;">Installer Responsibilities</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>						

1. Approving Civil Aviation Authority/Country: Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No: SO103029-3	
4. Organizations Name and Address:		DART AEROSPACE LTD 1270 Aberdeen Street Hawkesbury, ON, K6A 1K7 Canada Tel: 1 613 632 5200 Fax: 1 613 632 5246 www.dartacro.com			5. Work Order/Contract/Invoice 7601/2427	
6. Item:	7. Description:	8. Part No:	9. Quantity:	10. Serial/Batch No:	11. Status/Work:	
1	Skidtube	D205-634-011	1	B59280	New	
12. Remarks: TC STC SH96-88 Issue 3, FAA STC SR00563NY 08/08/11, EASA STC EASA.IM.R.S.01303 07/06/27, JCAB JAPAN STC-55-1-TYO 99/11/24						
13a. Certifies that the items identified above were manufactured in conformity to: <input checked="" type="checkbox"/> Approved design data and are in a condition for safe operation. <input type="checkbox"/> Non-approved design data specified in Block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulations specified in Block 12 Certifies that unless otherwise specified in Block 12, the work identified in Block 11 and described in Block 12 has been performed in compliance with the Canadian Aviation Regulations.			
13b. Signature: 		13c. Approved Organization Number: 9-89	14b. Signature: N/A		14c. Approved Organization Number: N/A	
13d. Name: Suzanne Bedford		13e. Date (dd/mm/yyyy): 24/Aug/2010	14d. Name: N/A		14e. Date (dd/mm/yyyy): N/A	
(Previously form 24-0078)						
Important: See notes						
Installer Responsibilities This certificate does not constitute authority to install. Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified. Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.						



File D

L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: January 5, 2011 5:21 PM
To: 'Jason Murdoch'; 'L Lacelle'; 'Marc Bellavance'
Cc: 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; swillems@dartaero.com; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition

Jason,

I would recommend that we NDT them.

David

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: Wednesday, January 05, 2011 1:59 PM
To: 'L Lacelle'; 'Marc Bellavance'
Cc: 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition

Will these tubes be NDT'd before they ship back to the customer? I do not want DART being held responsible for any issues that might occur down the road.....ya mean?

Jason Murdoch
Quality Coordinator
 jmurdoch@dartaero.com
 DART Aerospace Ltd.
 613-632-5200

*How to ship
New B/W?*

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 05, 2011 1:55 PM
To: 'Marc Bellavance'
Cc: 'Jason Murdoch'; 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition

With everyone gone for the last couple of weeks no one really touched them. They will get ground today, and alodined and we should be able to ship out by Friday.

LL

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: January 5, 2011 1:49 PM
To: 'L Lacelle'
Cc: 'Jason Murdoch'; 'Stow, Dan'; 'Susanne Sheldon'; 'Mike Petsche'; 'David Shepherd'; swillems@dartaero.com; 'Bill Beckett'
Subject: RE: Crosstube corrosion from Expedition
Importance: High

Linda,

1/06/11

Where are we with this? Customer wants to know.

Marc Bellavance
Technical/Shop Support

DART aerospace Ltd.

Tel: 613-632-5200 Ext. 243

Cel: 613-676-0992

Fax: 613-632-9311

E-mail: mbellavance@dartaero.com

Web: www.dartaero.com

Product Documentation: Verify Revision Status/Download [HERE!](#)



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From: Bill Beckett [<mailto:bbeckett@dartaero.com>]

Sent: December 20, 2010 12:55 PM

To: 'Peggy McDonald'; swillems@dartaero.com; 'L Lacelle'

Cc: 'Marc Bellavance'; Jason Murdoch; 'Stow, Dan'; Susanne Sheldon; 'Mike Petsche'; 'David Shepherd'

Subject: RE: Crosstube corrosion from Expedition

Peggy – ok, this is fine.

Sian – no-charge on a CSR. Please indicate ship date (talk to LL).

Linda – pls prepare work order **NB – no priming!** Ensure interior is protected during etch and alodine.

Bill

From: Peggy McDonald [<mailto:peggy@darths.com>]

Sent: December 20, 2010 12:48 PM

To: Bill Beckett

Cc: Marc Bellavance

Subject: Crosstube corrosion from Expedition

Importance: High

Hi Bill,

I spoke with Expedition this morning about the crosstube corrosion issue.

To resolve the issue, I took your recommendation and offered the crosstube rework at no charge.
(removal of the surface corrosion, acid etch and alodine)

PLEASE NOTE : the customer will do their own priming right before paint.

These can be returned to them early in the new year.

I recommend a MISC no charge PO to be sent to DAS.

Freight will be on the DHS account.

Please advise how you would like DHS to proceed.

1/06/11

Peggy

PLEASE NOTE OUR NEW CORPORATE OFFICE ADDRESS: 4650 North Avenue, Oceanside, California 92056

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1/06/11

List Lots

January 5, 2011 3:20:21 PM

Page 1 of 1

Criteria : All Items All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID					Lot Code	

D212-664-201CM	Main Warehouse	60450	12/14/10	1.0000			
----------------	----------------	-------	----------	--------	--	--	--

Crosstube, customer mat'l	RMAInspect						
---------------------------	------------	--	--	--	--	--	--

Total: 1.0000

64547

RA 110731

List Lots

January 5, 2011 3:20:06 PM

Page 1 of 1

Criteria : All Items All Locations All Warehouses All Quantity

Item ID	Warehouse ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Type Code	Comments
Item Name	Location ID				Lot Code		

D212-664-101CM	Main Warehouse	60522	12/14/10	1.0000			
----------------	----------------	-------	----------	--------	--	--	--

Crosstube, customer mat'l	RMAInspect						
---------------------------	------------	--	--	--	--	--	--

Total: 1.0000

64541

* Customer Property *

Do Not Damage

24110137 For investigation
& evaluation

NE216-380

- 5010210

10/12/07

* Customer Property *

Do Not Damage

24110137 For investigation

& evaluation

- NE216-380

- 5010210

10/12/07

ASAP

Work Order ID 64547

December 21, 2010 2:30:32 PM

Page 1

Item ID: D212-664-201

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Aft

Start Date: 12/08/10 Start Qty: 1.00



Cust Item ID:

Required Date: 12/09/10 Req'd Qty: 1.00



Customer: CU-DAR001

Reference: RMA RA110139 + Rework

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D212-664-241	Rev D								

100

0.00



QC

Memo

0.00

Quality Control

INSPECT RA110139
D212-664-201 B60450

See RMA EUCR report.

11-01-06